Work Order ID 60001

June 22, 2010 2:35:37 PM



Page 1

Item ID: **Revision ID:** D4048-041

Accept

Setup Start

Stop



Item Name:

Mounting Lug Assembly, LH

Start Date: 6/22/10 Required Date: 6/30/10

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

Approvals:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Insp.

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** Tool ID

Reject Accept Qty Qty

Reject Number

Stamp

Draw Nbr

Revision Nbr Α

D4048

100

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG D4048

0.00

110

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

0.00

120

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

Packaging

Dart .	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES							
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	<u> </u> 											
Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes I	No DQA :	DQA: Date:				
	Re	esolution:	Disposition	on:	QA: N	I/C Clo	sed:	Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE	NCR)					
DATE	CTED	Description of NC		Corrective Action Section B			Verifica	ion	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector		
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Work	Order	ID	60001
Luna 22	2010 2.2	5.20	DM



Page 2

Item ID: **Revision ID:**

D4048-041

Accept

Date:

Date:

Setup Start

Stop

Item Name:

Mounting Lug Assembly, LH

Start Date: 6/22/10 Required Date: 6/30/10 Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date: **Tooling:**

SPC (Y/N):

Run

Start Stop



Sequence ID/

Operation Work Center ID Description

QC:

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Memo

0.00

0.00

Quality Control

Dart Aerospace L	.td
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W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PROC	CEDURE CHA	NGE		Ву	Date	Ску	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			***************************************					-		
Part No	:	PAR #:	_ Fault Cate	gory:	NCR	Yes	No DQA :		Date:	
	R	esolution:	Disposition: QA: N/C Closed:						Date:	
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B				Verificat		Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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June 22, 2010 2:35:36 PM

Work Order ID: 60001

Parent Item:

Mounting Lug

D4048-041

Parent Item Name: Mounting Lug Assembly, LH



Location

55970

ENG

Start Date: 6/22/10

Required Date: 6/30/10

	DD D	1	.02.10					S	Start Qty: 1.00		Require	d Qty: ∄.0	0
Component Item ID/ Item Name	PP Rev:A as per Replacement Item ID	dwg revA DD 10 Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No			100	Each	312.0000	2		0/0/07	los	
				Location	<u>n</u>	Loc	<u>Qty</u>	Loc Code			,		
				ST357	114752		296 296				_		
				ST358	111732		16		_				
					113359 -		16				_		
AN960JD416	NAS1149D0463J	7	No '			100	Each	6.0000			10/0)	7/05	
Washer	M//\$			<u>Locatio</u>	n	Loc	Ωtv	Loc Code					
				ST357	<u></u>	<u> Loc</u>	- 6	Lot Cout					
				01307	107939		6		_		-		
D4048-1		Manufactured	No			100	Each	1.0000	1	1//	_	, ,	
Mounting Lug					·					45	12/0	7/05	
	•			<u>Locatio</u>	<u>n</u>	Loc	<u>Qtv</u>	Loc Code					
				ST468	55967		l 1		_	1	-		
D4048-3	1111 I RO I	Manufactured	No		33901	100	Each	1.0000		1//			

Loc Qty

Loc Code

Dart Aerospace Ltd	D	art	Aer	ospa	ice L	_td
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date (у	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
							<u> </u>		
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:		Date:	
Resolution:								Date:	
NCR:		V	VORK ORE	DER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC	1	Corrective Action Section		Sign & Verificati		Approval	Approval
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section (Section C	Chief Eng	QC Inspector

Picklist Print

June 22, 2010 2:35:37 PM

Work Order ID: 60001

Parent Item:

D4048-041

Parent Item Name: Mounting Lug Assembly, LH

Manufactured

Purchased



Start Date: 6/22/10

Required Date: 6/30/10

Start Qty: 1.00

Required Qty: 1.00

D4048-9

Bushing

Location ST111

No

58071

Loc Qty 32 32

Each

Each 100

100

Loc Code

32.0000

3,026.000

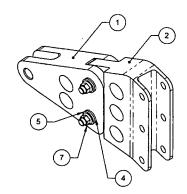
MS21042L4

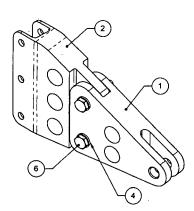
Nut

Location	Loc Qty
ST300	3026
113422	68
114523	28
114718	930
114784	2000

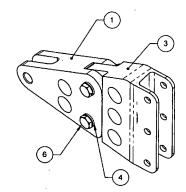
Loc Code

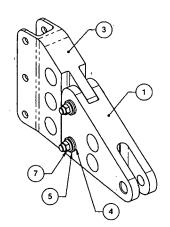
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Part No: PAR #:								Date: _		
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ITEM	QTY -041	QTY -042	P/N	Description	
	Х		D4048-041	MOUNTING LUG ASSY	
		Х	D4048-042	MOUNTING LUG ASSY	
1	1	1	D4048-1	MOUNTING LUG	
2	1		D4048-3	MOUNTING LUG	
3		1	D4048-4	MOUNTING LUG	
4	4	4	D4048-9	BUSHING	
5	2	2	AN960JD416	WASHER	
6	2	2	AN4-14A	BOLT	
7	2	2	MS21042L4	NUT	

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SHOP COPY RETURN 101 ENGINEER: n UNCONTROLLED CO "" SUBJECT TO ASSENDE LAND WITHOUT NOTICE WORK ORDER NO. 4000/

Α.	NEW IS	SUE	RF	10.01.29					
REV.			DESCRIPTION BY	DATE					
DESIG	N	RF	DART AEROSPACE	ITD					
DRAW	N	RF		HAWKESBURY, ONTARIO, CANADA					
CHECKED (1)		W.	DRAWING NO.	REV. A					
MFG. A	PPR.	91	D4048	SHEET 1 OF 9					
APPRO	VED	140	TITLE	SCALE					
DE API	PR.	-#	MOUNTING LUG ASSY	NTS					
DATE	10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND COMPONENTIAL, AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMANDACTED TOWN HOTHER PERSON WITHOUT WRITTEN PERSONS ON DATE ADOPTION.						

D4048-042 MOUNTING LUG ASSY (SHOWN)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4048-041/-042: 1.16 lbs
8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

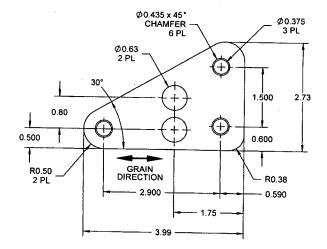
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W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CH	ANGE	By Date C			Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-								

Part No	.	PAR #:	Fault Cat	tegory:	_ NCR: \	es N	lo DQA:		Date:	
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DATE	STEP	Description of NC			tion B	0	Verifica		Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	<u> </u>	Chief Eng	QC Inspector
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0.290 2 PL 1.155^{+0.015} -0.000 0.293 - 1.00 REF R0.03 2 PL 2 PL - 0.420^{+0.015} -0.000 0.415+0.015 - R0.188 CHAMFER TYP - 1.38 -



D4048-1 MOUNTING LUG

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-220/8 (OR AMS 4160) REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.315 HOLES PRIOR TO POWDER COAT 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A
7) WEIGHT: 0.47 lbs

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DESIGN	RF	DART AEROSPACE	ITD
DRAWN	RF	HAWKESBURY, ONTARIO, CAN	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	91	□ D4048	SHEET 2 OF
APPROVED	149	TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPA THIS DOCUMENT OF PROVIDE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXP MOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMMANNICATED TO ANY	RESS CONCITION THAT IT IS OTHER PERSON WITHOUT

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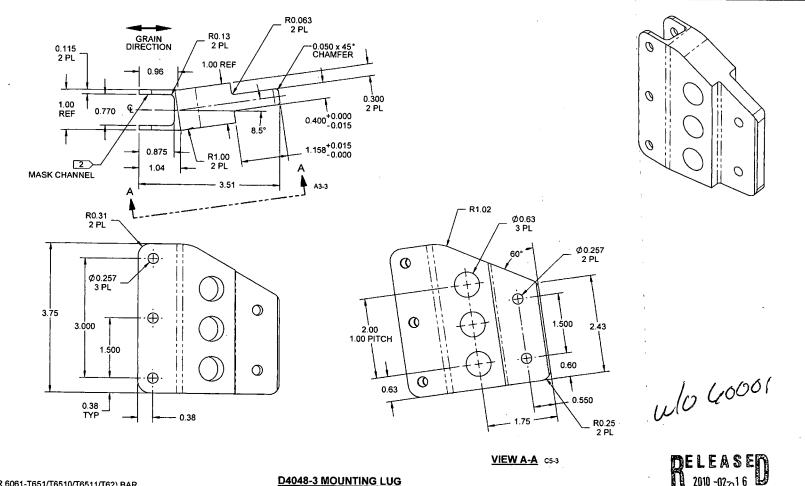
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	С	ate	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No	DQA:		Date:	
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CHECKED	a)	DRAWING NO.	REV. A
MFG. APPR.	91	D4048	SHEET 3 OF
APPROVED	148	TITLE	SCALI
DE APPR.		MOUNTING LUG ASSY	NTS
DATE 10.0	1.29	COPYRIGHT © 2010 BY DARY AEROSP, THIS DOCUMENT OF PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXI- NOT TO BE USED FOR ANY PURPOSE OF COPYRIGHT OF COMMENT ATTO TO ANY	THE SE CONCETTON THAT IT IS

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NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QC-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QC-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-3) PRIOR TO POWDER COAT
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A

6) IDENTIFICATION: N/A 7) WEIGHT: 0.61 lbs

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3

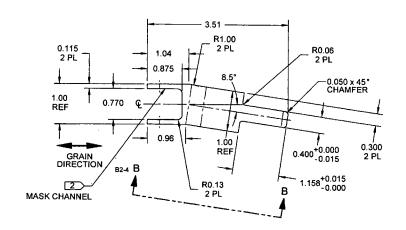
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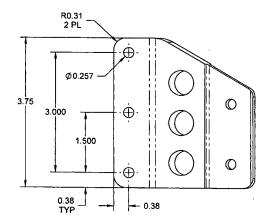
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	Re	solution:	Disposit	ion:	QA:	N/C CI	osed:		Date:	
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B	Sign &	Verifica Section		Approval Chief Eng	Approval QC Inspector
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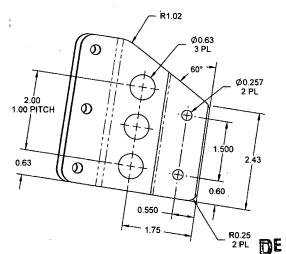


D4048-4 MOUNTING LUG

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VIEW B-B C6-4

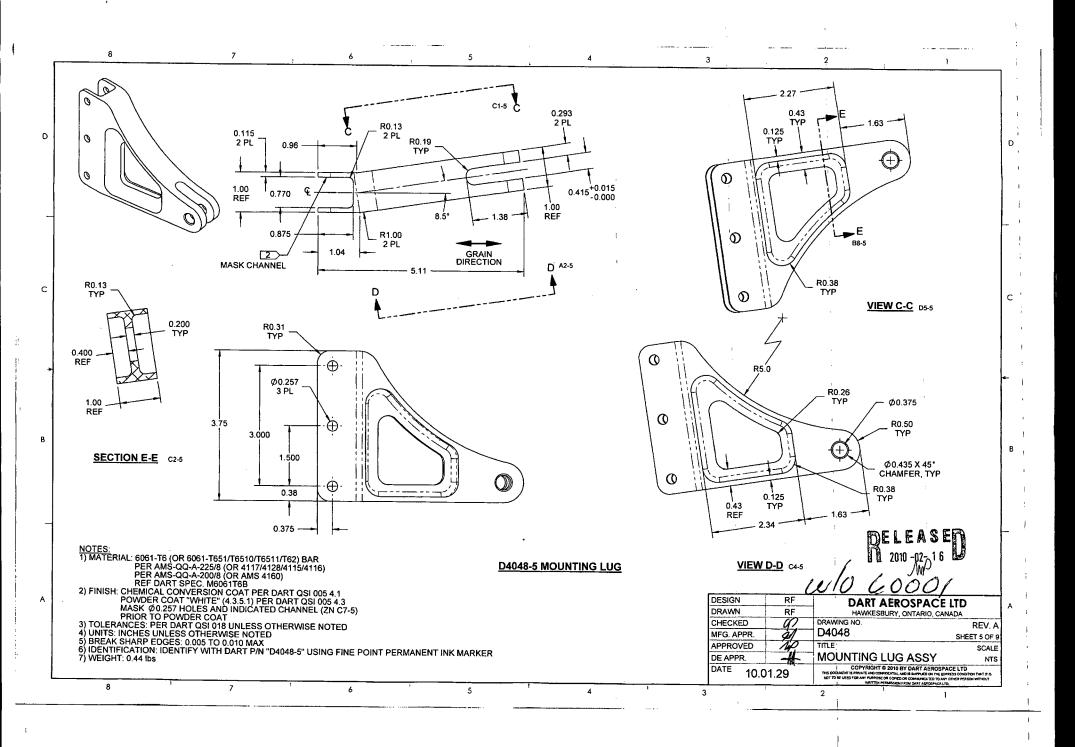
DESIGN RF DART AEROSPÀCE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4048 MFG. APPR. SHEET 4 OF 9 APPROVED TITLE SCALE **MOUNTING LUG ASSY** DE APPR. NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT BE PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON 10.01.29

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.61 lbs

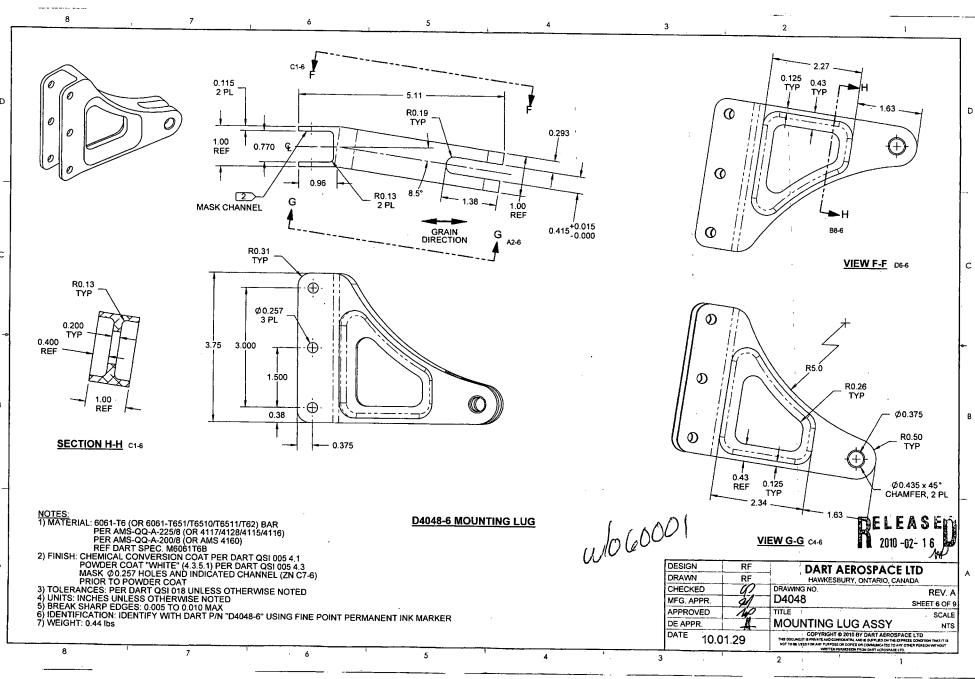
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-4)
PRIOR TO POWDER COAT
3 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

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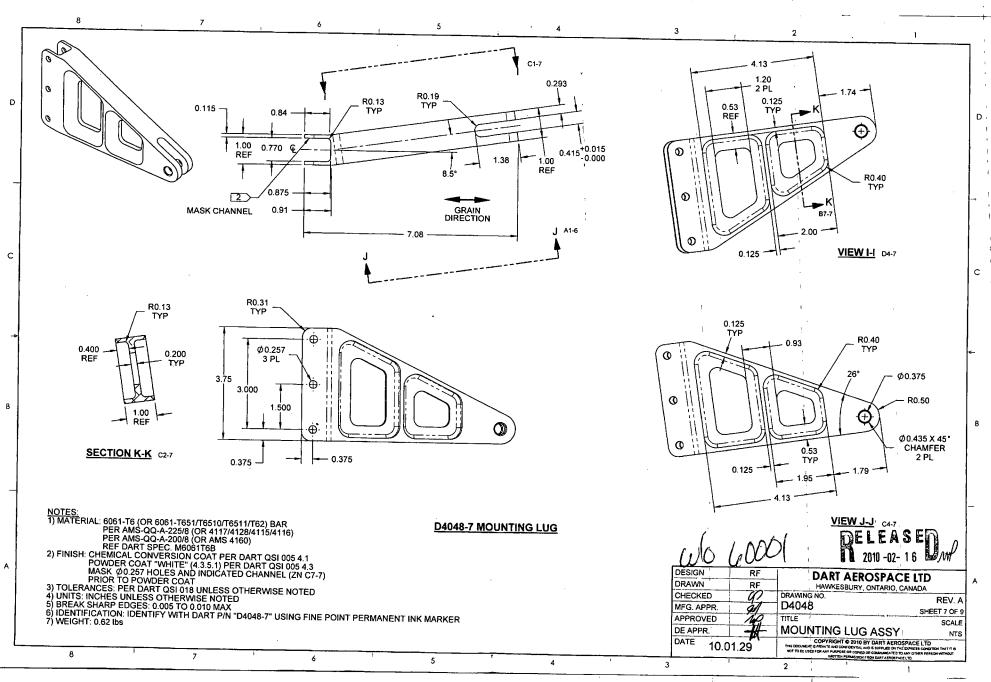
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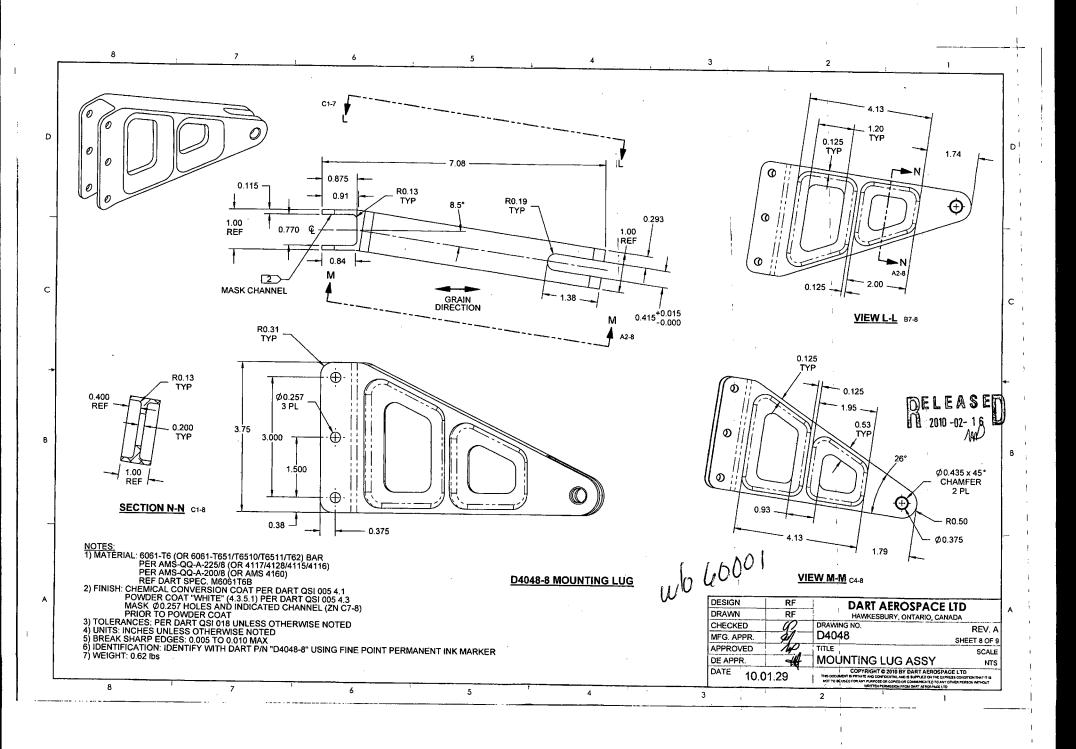
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DATE	STEP	Description of NC		Corrective Action Section		Verifica	ton	Approval	Approval
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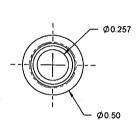
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	R	esolution:	Dispositi	on:	QA: N/C C	losed:		Date: _	
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DATE	STEP	Description of NC	Initial	Corrective Action Section	on B	Verifica		Approval	Approval
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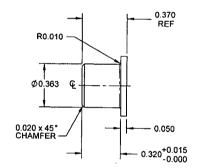


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	Re	solution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	ion B Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
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W/O:			WC	ORK ORDER CHANG	ES					
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DATE	CTED	Description of NC		Corrective Action Section			Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ite	Section		Chief Eng	QC Inspector
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18										
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D4048-9 BUSHING

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

ub 6001

DESIGN	RF	DART AEROSPACE	IID			
DRAWN	RF_	HAWKESBURY, ONTARIO, CAN	IADA			
CHECKED	G)	DRAWING NO.	REV. A			
MFG. APPR.	91	D4048	SHEET 9 OF 9			
APPROVED	14	TITLE	SCALE			
DE APPR.	_#	MOUNTING LUG ASSY	NTS			
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